



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3915-041
Job Sheet 177261



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/9/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Large Fab-5		DO 2018-05-25
100	Large Fab	1 pcs	5/11/18	5/11/18	0.00	3.33	Large Fab 2		18-5-21
110	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC9		CPL
120	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC5		CPL
130	HandFinish	1 pcs	5/11/18	5/11/18	0.00	1.00	HandFinish1		SA 18-05-28
140	Large Fab	1 pcs	5/11/18	5/11/18	0.00	3.33	Large Fab 2		18-5-20
150	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC9		CPL
155	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC5		CPL
157	HandFinish	1 pcs	5/11/18	5/11/18	0.00	1.00	HandFinish1		SA 18-05-28
160	Powdercoat	1 pcs	5/11/18	5/11/18	0.00	0.83	Powdercoat1		BL 18-6-4
170	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC3		18-6-4
180	HandFinish	1 pcs	5/11/18	5/11/18	0.00	0.81	HandFinish4		18-6-4
190	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC5		18-6-4
200	Packaging	1 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-2		18-6-4
210	QC21-SA	1 Ea	5/11/18	5/11/18	0.00	0.00	QC21		21 JUN 05 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND

ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

120 - -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4

130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - 1- weld (4) corners

155 - ***inspect fit of lid with base***

157 - 1- realodine corners ***do not acid etch***

160 - 1- touch up corner with alodine only 2- Plug holes prior to finish 3-Mask this area prior to finish View B-B 1ST COAT:

START TIME: 7:00 OVEN TEMPERATURE: 320° FINISH TIME: 8:00 ***** 2nd

coat if necessary***** 2ND COAT: START TIME: OVEN TEMPERATURE:

FINISH TIME:

180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

003635

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 Ea (4 ea)	90-Start up Operation	5023591
D3915-1	Rib	2 Ea (2 ea)	90-Start up Operation	5067407
D4016-5	Hinge Half, Light Lid	3 Ea (3 ea)	90-Start up Operation	5039258
D4019-3	Rib	3 Ea (3 ea)	90-Start up Operation	5067121
D4035-047	Lid Rib Assembly, Aft (Light)	2 Ea (2 ea)	90-Start up Operation	5071028
D4056-1	Label Plate	1 Ea (1 ea)	90-Start up Operation	157507
D2728-1	Dart Logo Label Small	1 Ea (1 ea)	180-HandFinish	
D4029-041	Webbing (Long Basket)	1 Ea (1 ea)	180-HandFinish	5065815
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-HandFinish	5048405
NAS1149DN949J	Washer	34 Ea (34 ea)	180-HandFinish	FM178256

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2957	4	0	0
	D3915-1	2	10	0
	D4016-5	3	43	0
	D4019-3	3	11	0
	D4035-047	2	0	0
	D4056-1	1	20	0
	D2728-1	1	0	0
180-HandFinish	D4029-041	1	5	0
	MS20600-AD4W4	34	923	0
	NAS1149DN949J	34	224	0

Part Specifications

Specifications could not be found.

Linda Lacelle

From: Eric Downing
Sent: Wednesday, May 9, 2018 8:36 AM
To: Marc Bellavance; David Shepherd; Chris Provencal
Cc: Harvey Siemens; Ryan Williamson; Jason Leroux; Linda Lacelle; Robert Aboud; Marcel Daviau; Sian Willems
Subject: RE: NCR D4029-041 Webbing

Hey Guys,

This maybe a crazy idea but could we send Aerotex the basket lid for them to correctly fit the webbing on so we do not have to do a bunch of back & forth?

The lid that was assembled first is now scrape due to the amount of rivet fod in the lid that cannot be removed.

Eric

From: Marc Bellavance
Sent: Wednesday, May 09, 2018 8:19 AM
To: David Shepherd <dshepherd@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Eric Downing <edowning@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: RE: NCR D4029-041 Webbing

David/Chris,

I agree with you both. We've seen similar issues in the past and had to absorb replacement costs for webbing that were not even that loose. Definitely, that webbing should not be installed or put in stock. A constructive meeting with our supplier as proposed by Marcel is à propos here.

Marc

From: David Shepherd
Sent: Tuesday, May 08, 2018 8:50 PM
To: Chris Provencal <cprovencal@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Eric Downing <edowning@dartaero.com>; Sian



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Container No: S074525



Part: D3915-041

Job No: 177261

Serial No/Batch: S074525

Revision: F

Inspector:

Date: 06/26/18

Linda Lacelle

From: Chris Provencal
Sent: Friday, June 1, 2018 9:39 AM
To: Steven Drouin
Cc: Eric Downing; Marcel Daviau; Jason Leroux; Patrick Duval; Robert Aboud; Patrick Lussier; David Shepherd; Ryan Williamson; Harvey Siemens; Linda Lacelle
Subject: RE: NCR D4029-041 Webbing

Steve D,

Can you put D4029 Rev. B under review until we address the manufacturability of the web. Also put the associated top level basket kits under review (use where-used in plex).

Chris

From: Chris Provencal
Sent: Friday, June 01, 2018 9:39 AM
To: Linda Lacelle <llacelle@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Lussier <plussier@dartaero.com>
Subject: RE: NCR D4029-041 Webbing

Linda,

We should ship the Monday order as a Rev. A as well.

Chris

From: Linda Lacelle
Sent: Friday, June 01, 2018 9:24 AM
To: Chris Provencal <cprovencal@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>
Cc: Eric Downing <edowning@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Patrick Duval

<pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Lussier <plussier@dartaero.com>

Subject: RE: NCR D4029-041 Webbing

Can someone give me a response on this pls- I have moved order 5464 to Monday – but would need to bring another webbing over to Tulmar TODAY to get this done...

Thx

L

From: Linda Lacelle

Sent: Tuesday, May 29, 2018 11:30 AM

To: Chris Provencal <cprovencal@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Cc: Eric Downing <edowning@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Lussier <plussier@dartaero.com>

Subject: RE: NCR D4029-041 Webbing

Can someone pls let me know asap for order 5464 >?????

From: Linda Lacelle

Sent: Monday, May 28, 2018 10:33 AM

To: Chris Provencal <cprovencal@dartaero.com>; David Shepherd <dshepherd@dartaero.com>

Cc: Eric Downing <edowning@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Patrick Lussier <plussier@dartaero.com>

Subject: RE: NCR D4029-041 Webbing

This is also going to affect order 5464 (H2i – Helicopters, Portugal)– do we do the same with this order pls? Due to ship on May 30th.

From: Lacey Cantin

Sent: Monday, May 28, 2018 9:56 AM

To: Linda Lacelle <llacelle@dartaero.com>; Mike DiDomenico <mdidomenico@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>; Patrick Lussier <plussier@dartaero.com>

Cc: Eric Downing <edowning@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Jason Leroux <jleroux@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>

Subject: RE: NCR D4029-041 Webbing

Hi All,